

# Work Order ID 57982

April 21, 2010 10:06:24 AM



Page 1

Item ID: D3916-5

Accept



Setup Start



Revision ID:

Item Name: Light Rib

Stop



Start Date: 21/04/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 21/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*BA*

Date: 10-4-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3916

A

100



Large Fab

0.00

Memo

0.00

1- Cut tube 50"

*SAD 10-05-07*

2- Bend tube with manuel pipe bender as per DT9566

\*\*\* Make line at 9.00" annd use jig for other line\*\*\*

3- Trim access tube material to finish size as per dwg D3916

*9*

*PD 10.05.07*

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*S w/ 65-10*

*49*

120



Packaging

Packaging

Identify as per dwg & Stock Location: *WA*

0.00

Memo

0.00

*SAD*

*10-05-10*

*9*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57982**

April 21, 2010 10:06:24 AM



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Setup Start



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Required Date: 21/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/12 *[Signature]*  
mf  
10-5-10

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**NOTE:** Date & initial all entries

# Picklist Print

April 21, 2010 10:06:29 AM

Page 1

Work Order ID: 57982

Parent Item: D3916-5

Parent Item Name: Light Rib

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC  
as per dwg revA 10.03.15 verified by:EC

IPP Rev:B

Start Date: 21/04/2010

Required Date: 21/04/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.500W.049		Purchased	No			100	f	317.5306	26.3116			



Square Tubing



SAD 10-05-07

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

298

114426

298

Main Warehouse

MAT018

19.5306

114004

3.5

114161

16.0306

39.4674

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

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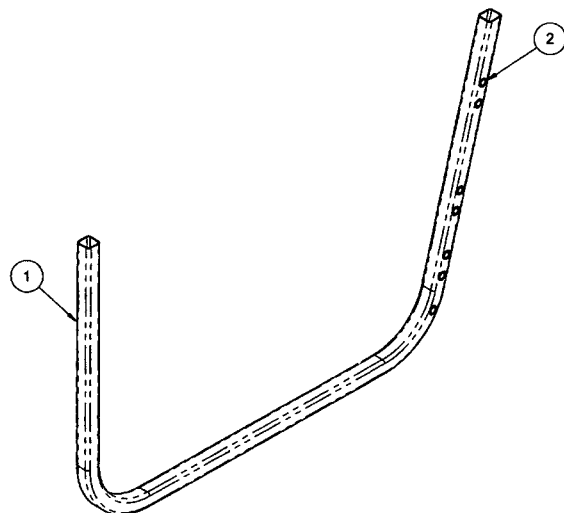
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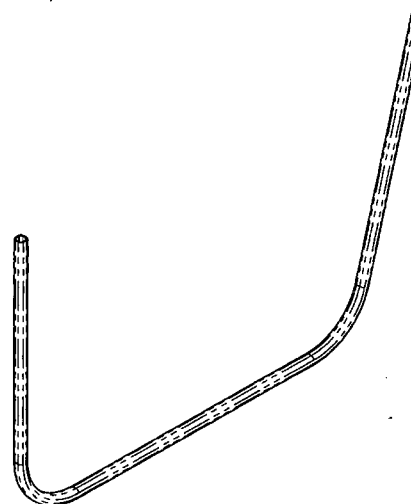
**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING

4 SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 37982  
B810-4-21



**D3916-041 RIB ASSY**



**D3916-5 LIGHT RIB**

**RELEASED**  
 2010-03-12  
 JWP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.03.04		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3916	REV. A
TITLE RIB ASSY, 350 BASKET	SHEET 1 OF 4
SCALE NTS	

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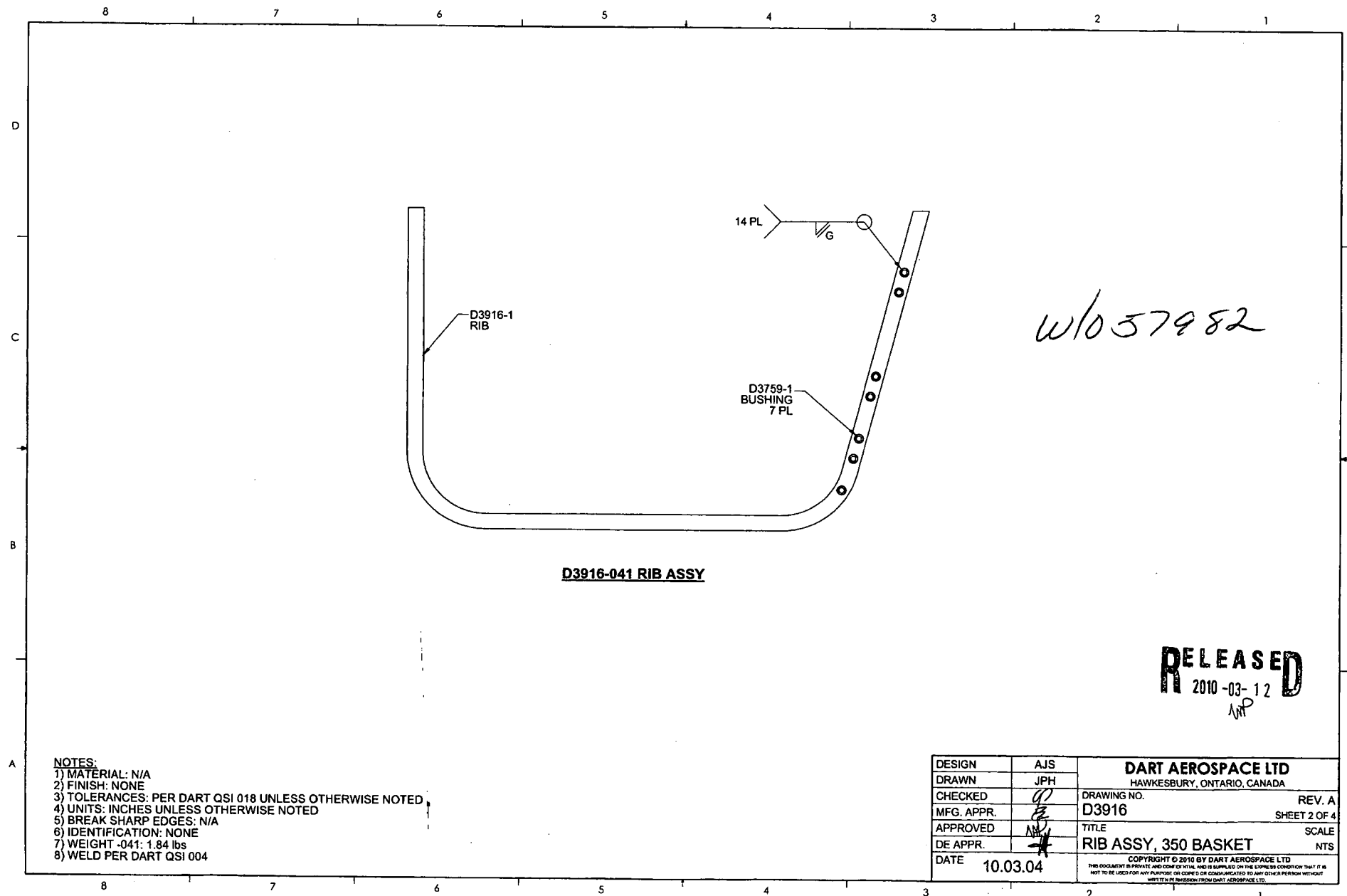
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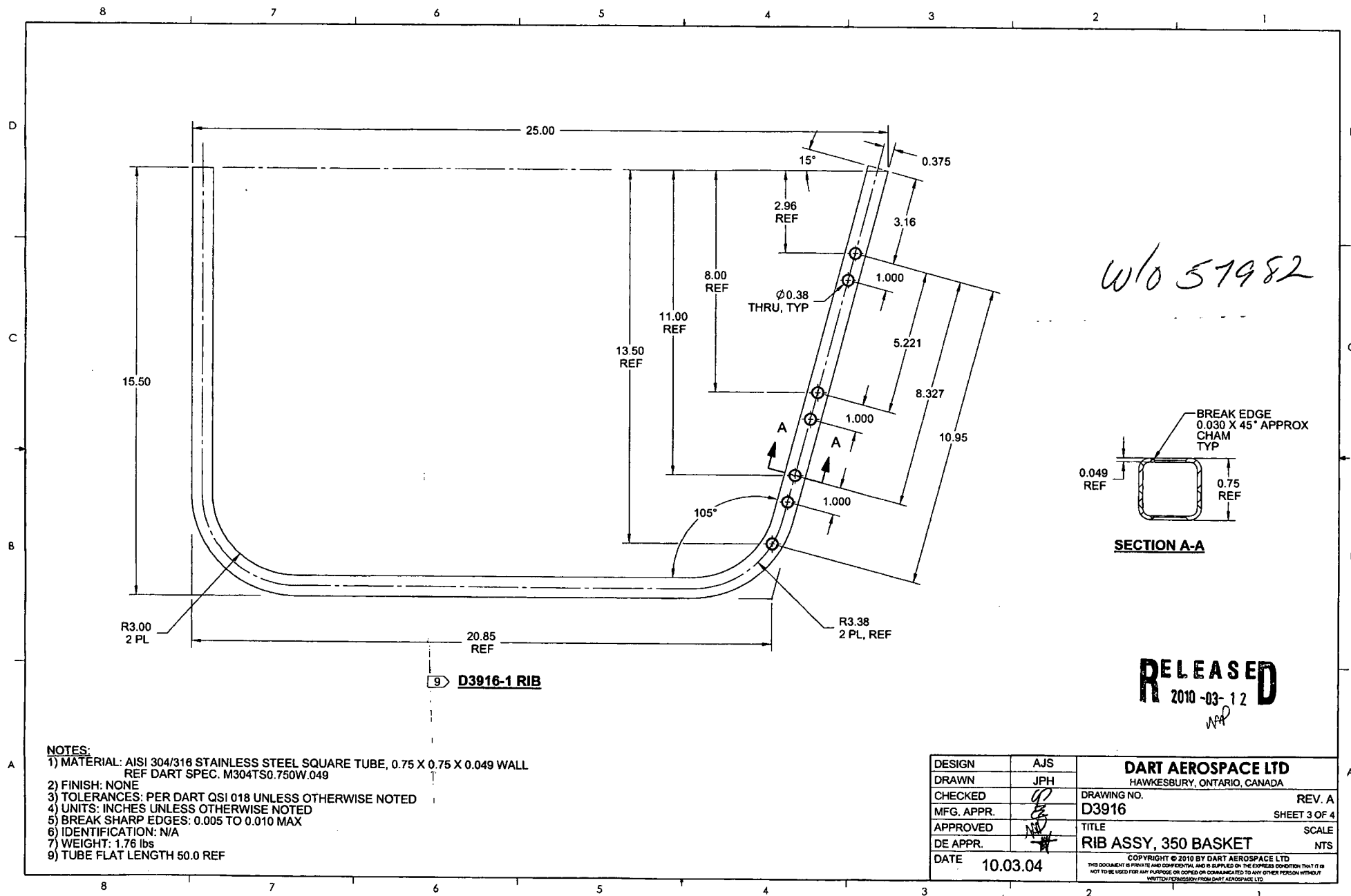
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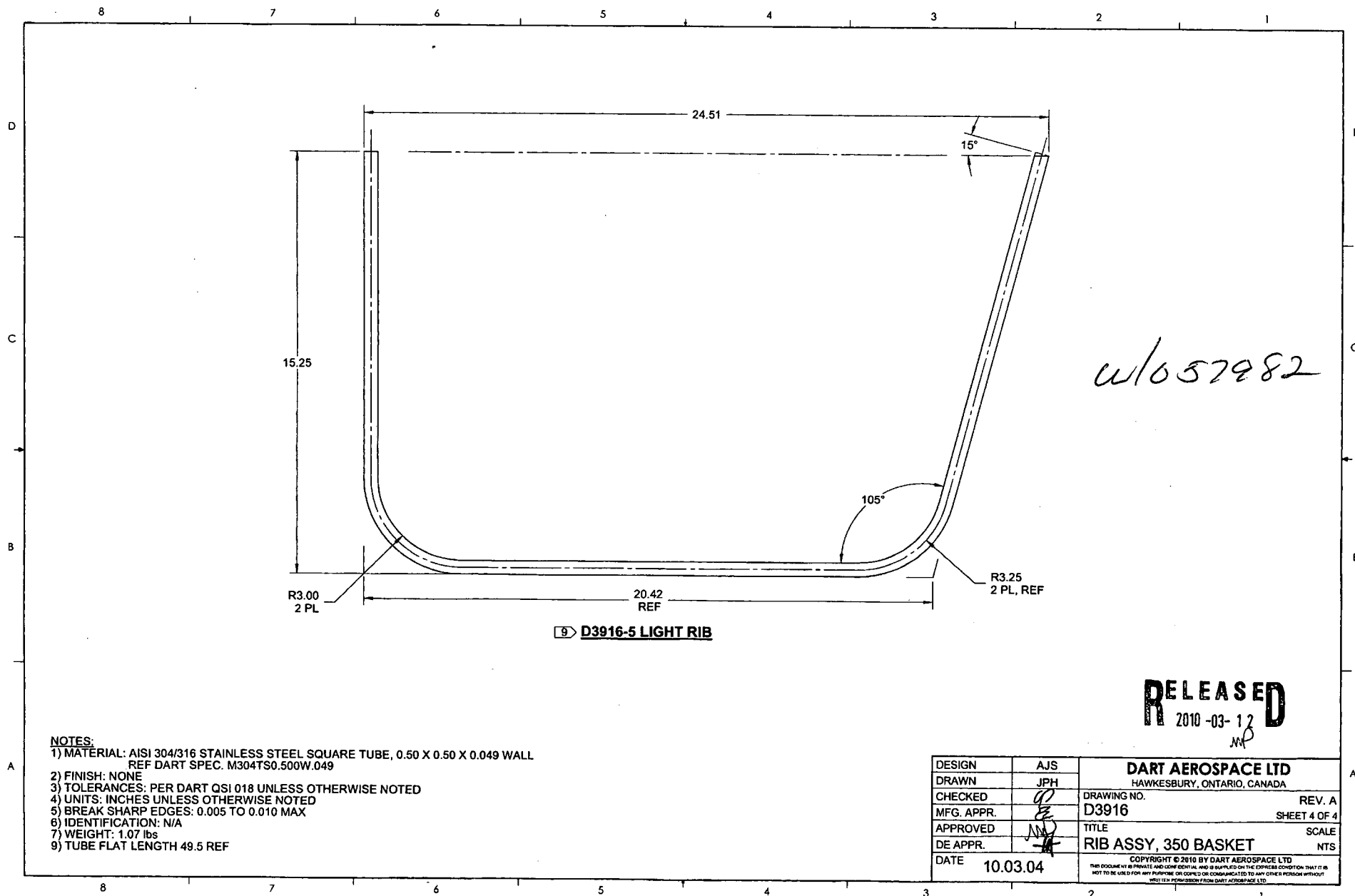
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**RELEASED**  
2010-03-12

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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